

Work Order ID 73363

Wednesday, August 31, 2011 11:39:18 AM

Ship
Today



Page 1

Item ID: D3199-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 8/31/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/12/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan:

CL

Date: 11/08/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
----------	--------------	--	--	--	--	--	--	--	--

D3199	E								
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100



FLOW WATER JET

0.00

111-9-14

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3199

364 .040

Dwg Rev: F

Prog Rev: F

Deburr if required

35

110



QC2- Inspect parts off machine FAI/FAIB

0.00

111-9-14

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73363

Wednesday, August 31, 2011 11:39:18 AM



Page 2

Item ID: D3199-1

Accept



Setup

Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 8/31/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/12/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

S u10914

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

SB 11/09/14

Small Fab

Memo

Form as per dwg D3199 use DT9723

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S u10916

Memo

0.00

Counter

x35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73363

Wednesday, August 31, 2011 11:39:18 AM

Page 3

Item ID: D3199-1

Accept



Setup

Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 8/31/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/12/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



Powdercoat

Powder Coating

W117338

Operation
Description

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

8:30 0.00
320 °F
9:00

35x Ø m-f 11/09/16

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

35 BL 11-9-16

170



Packaging

Identify as per dwg & Stock Location: ST 234A 0.00

Memo

0.00

S9 11-09-16 C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73363

Page 4

Wednesday, August 31, 2011 11:39:18 AM

Item ID: D3199-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 8/31/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/12/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

 11-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, August 31, 2011 11:39:15 AM

Work Order ID: 73363



Parent Item: D3199-1



Parent Item Name: Bracket

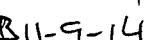
Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 30.00

Required Qty: 30.00

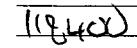
Comments: IPP Rev:C Removed Scribing 05-11-05 JLM
IPP Rev:D As per Rev B 06-11-24 JLM IPP Rev:E
11.03.31 as per ecn 11-531 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased		No		100	sf	212.4072	0.099	3.126316	3.4 	8/31-9-14 	

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	212.4072	
116623	0.2	
117550	9.363	
117933	79.3442	
118400	123.5	

35


118400


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod-Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73363
Description: Bracket	Part Number:	D3199-1
Inspection Dwg: D3199 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: B	Audited by: f	Preliminary Approval: 5
Date: 11-09-14	Date: 11/09/14	Date:

Rev	Date	Change	Revised by	Approved
A	06.10.20	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	11.03.08	Dwg Rev updated	KJ	

8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

BEND LINES
REFR0.105
TYP

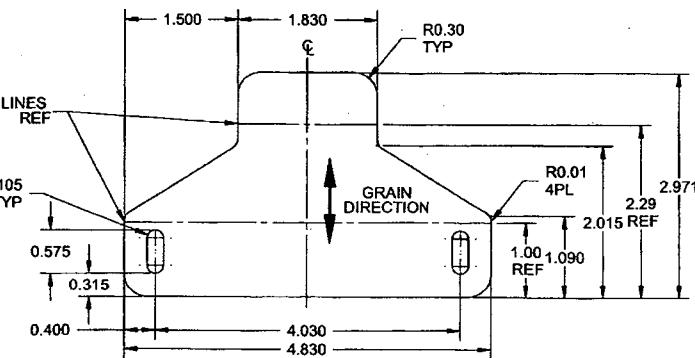
0.575

0.315

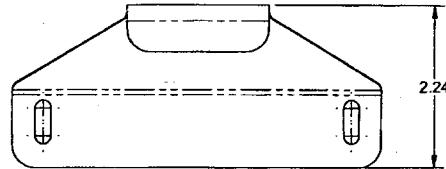
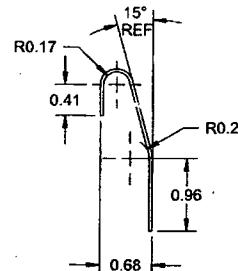
0.400

4.030

4.830



D3199-1F FLAT PATTERN

D3199-1 BRACKET
MADE FROM D3199-1F

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
No. 73363
C4110831

RELEASED
2011-07-18
MP

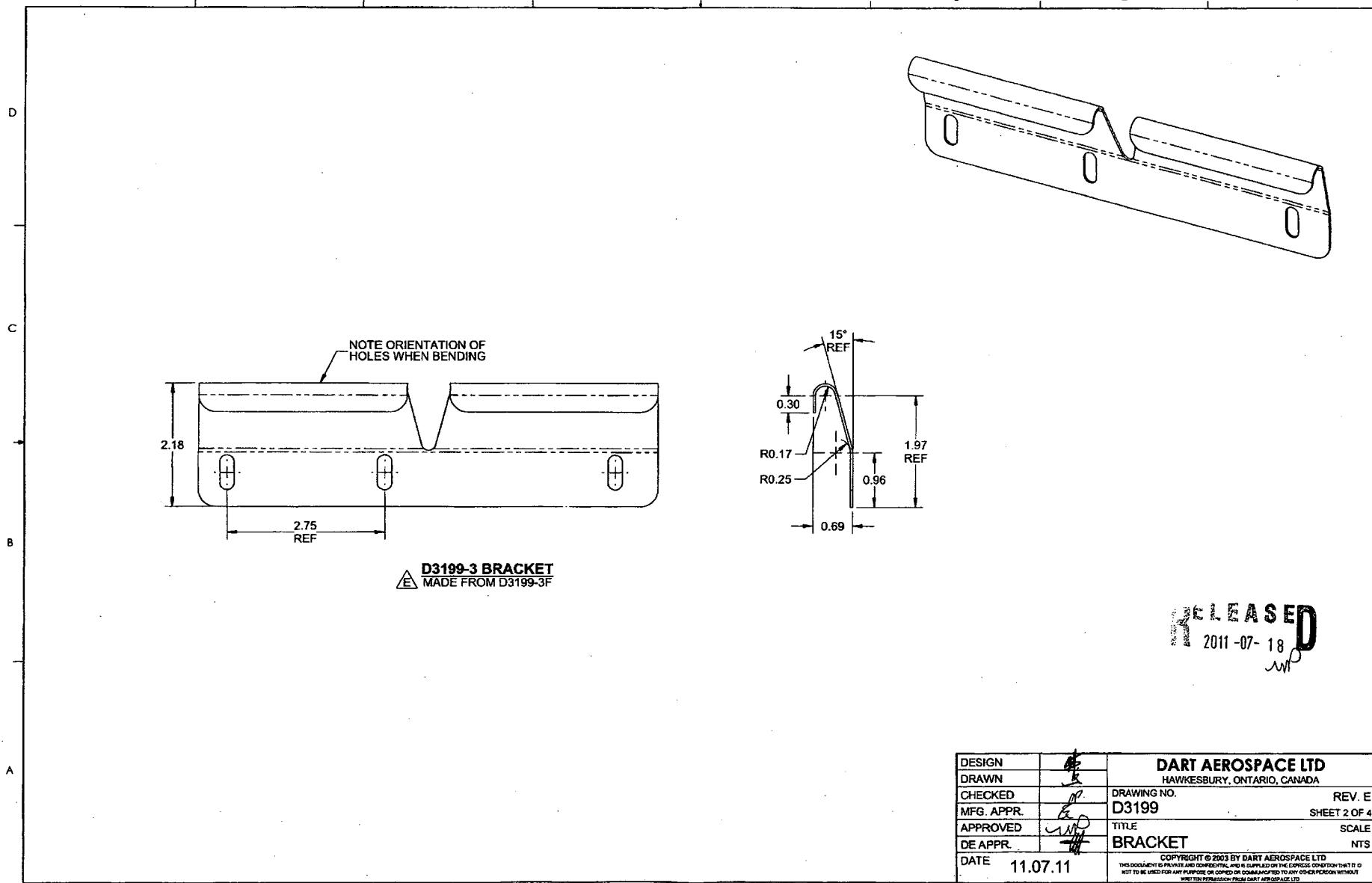
E	RE-DESIGNED D3199-3/4-3F PER CUSTOMER FEEDBACK TO OPTIMIZE FIT.	MB	11.07.11
D	RE-DESIGNED D3199-3/4-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF.: PART1-78	MB	11.03.21
C	ADD 3/4 PART (SHEET 2-4)	HS	09.11.19
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	08.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	DP	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HP	DRAWING NO.	REV. E
MFG. APPR.	ED	D3199	SHEET 1 OF 4
APPROVED	ED	TITLE	SCALE
DE APPR.	ED	BRACKET	NTS
DATE	11.07.11	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/4 = 0.26 lbs EACH

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

C

B

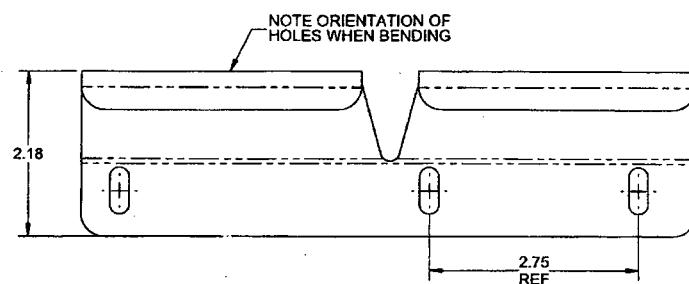
A

D

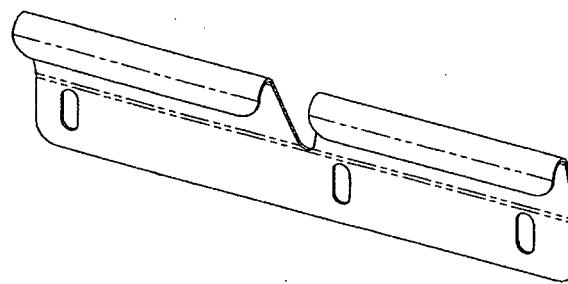
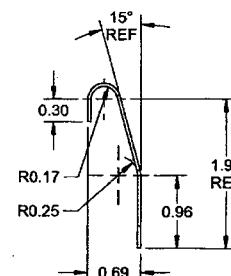
C

B

A



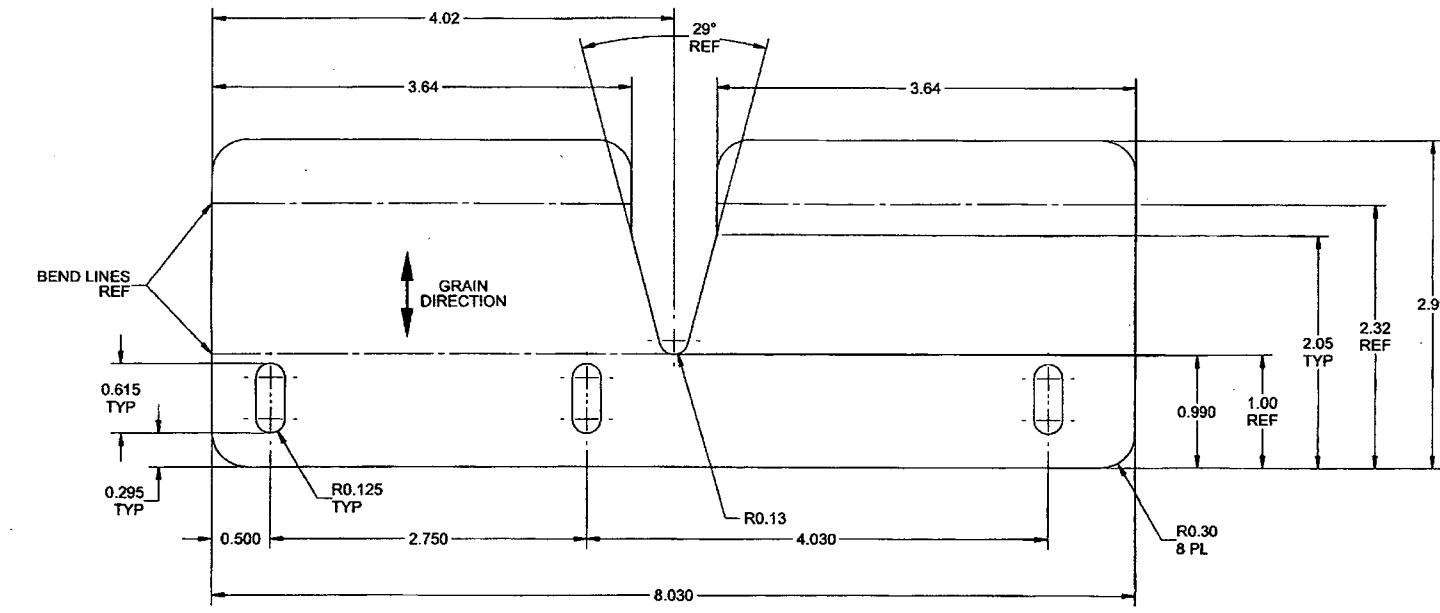
D3199-4 BRACKET
MADE FROM D3199-3F



RELEASED
2011-07-18
MM

DESIGN	<i>1</i>	DART AEROSPACE LTD
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>1</i>	DRAWING NO.
MFG. APPR.	<i>1</i>	REV. E
APPROVED	<i>1</i>	D3199
DE APPR.	<i>1</i>	SHEET 3 OF 4
DATE	11.07.11	SCALE
		NTS
		BRACKET
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		WRITTEN APPROVAL FROM DART AEROSPACE LTD

8 7 6 5 4 3 2 1



△ D3199-3F FLAT PATTERN

RELEASED
2011-07-18
JW

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.25 lbs

DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	DRAWING NO.
MFG. APPR.	<i>AB</i>	D3199
APPROVED	<i>AB</i>	REV. E
DE APPR.	<i>AB</i>	SHEET 4 OF 4
DATE	11.07.11	SCALE
		NTS
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